

64.77

Dart Aerospace Ltd.

Date: Monday, 09/03/2009 1:46:06 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 46343B	
Estimate Number : 10462	
P.O. Number :	Part Number : D32782
This Issue : 09/03/2009 S.O. No. :	Drawing Number : D3278 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : C
Previous Run : 45401B	Material :
Written By :	Due Date : 24/03/2009 Qty: 40 Um: Each
Checked & Approved By : <u>JUD 09.03.09</u>	
Comment : Est:A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.00 x 2.00
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**Comment:** Qty.: 0.2454 f(s)/Unit Total: 9.8154 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: M110829

SD 09/03/24

2.0	SHEAR Band Saw	SHEAR
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**Comment:** SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

SD 09/03/24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

mme 09/03/25 J.L 09/03/28 (38)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

mme 09/03/25 J.L 09/03/28 (38)


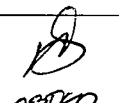



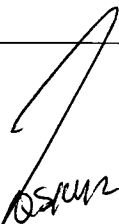
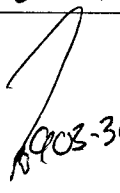
5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SP 09/03/28 (39)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3278-2 PAR #: N/A Fault Category: Prod/Machine Part NCR (Yes) No DQA: D Date: 09/04/03
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/04/06

NCR: 46343B		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/25	3.0	edge finder hop on To piece and made a groove when taking origins R.C. Human error	 09/03/25	Scrap + destroy and replace B2	mmf 09/03/25	S 9/3/25	 09/03/25	S 09/03/25
09/03/25	3.0	.098 holes are .113 because center drill goes to far into piece R.C. programmer wrong C'drive operator error	 09/03/25	Scrap + destroy and replace B2	mmf 09/03/25	S 9/3/25	 09/03/25	S 09/03/25
09/03/28	5.0	These parts are under size when QC3 was done. Dimension of .125 is .104 R.C. 7 parts left during operation	 09/03/28	Scrap & destroy No replace qty 2, 1 part was replaced from the NCR on W/O 46343A.	JB 09/03/28	JB 09/08/31	 09/08/31	 09/08/30

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:46:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 46343B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(38)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Ed 09/03/31

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

13:10

OVEN TEMPERATURE:

300°

FINISH TIME:

13:40

CMO/BR

09/03/31

(X38)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-04-01

(38)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 81

SS 09/04/01

(38)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/03

(39)

Job Completion



MF 09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46343B
Description: Support		Part Number: D3278-2
Inspection Dwg: D3278	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.100	✓			
0.359	+/-0.005	.361	✓			
0.609	+/-0.010	.609	✓			
0.250	+/-0.010	.250	✓			
1.480	+/-0.005	1.479	✓			
R0.125	+/-0.010	R.125	✓			
0.119	+0.005/-0.004	.119	✓			
2.439	+/-0.010	2.439	✓			
1.980	+/-0.010	1.978	✓			
R0.13	+/-0.030	R.13	✓			
Ø0.257	+0.005/-0.000	.260	✓			
R0.375	+/-0.010	R.375	✓			
0.875	+/-0.010	.878	✓			
0.500	+/-0.010	.499	✓			
R0.400	+/-0.010	R.400	✓			
R1.00	+/-0.030	R1.00	✓			
1.720	+/-0.010	1.722	✓			
R0.125	+/-0.010	R.125	✓			
0.125	+/-0.010	.125	✓			

Measured by: mwf	Audited by: JF	Prototype Approval:	N/A
Date: 09/03/25	Date: 09/03/28	Date:	N/A

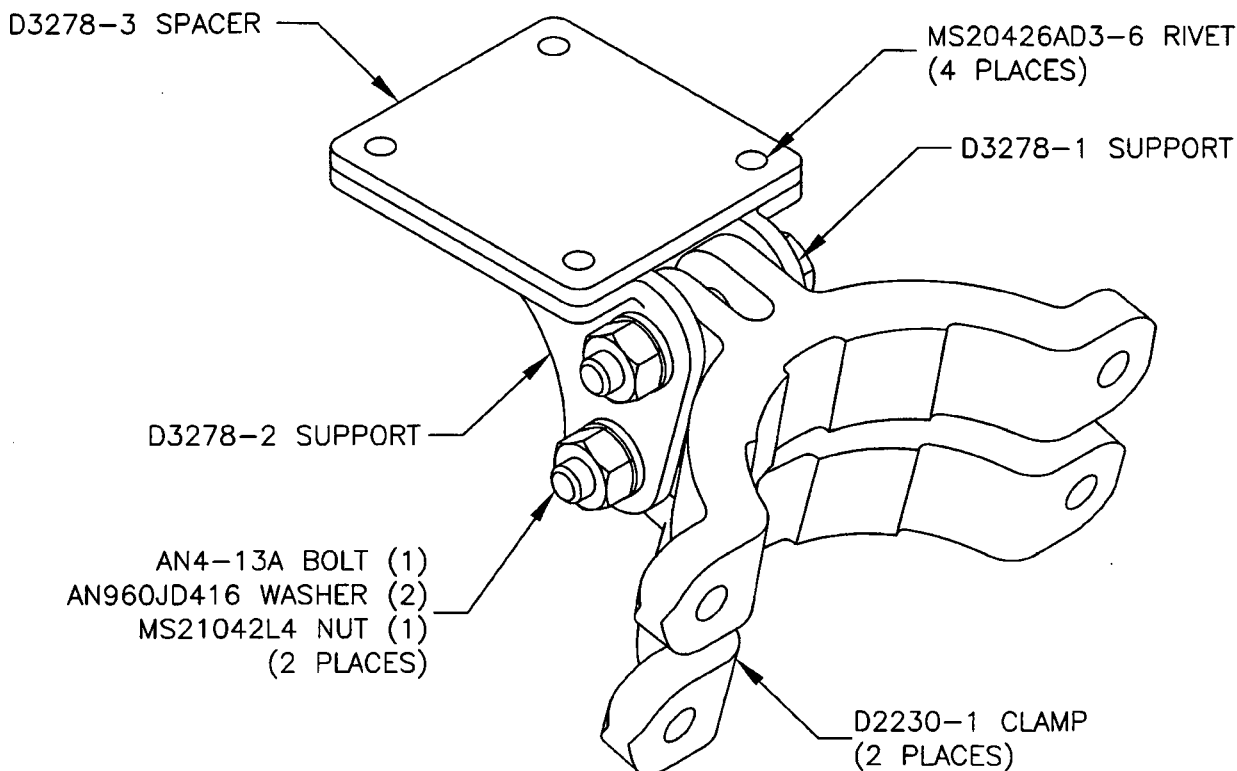
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	EF



DESIGN 97	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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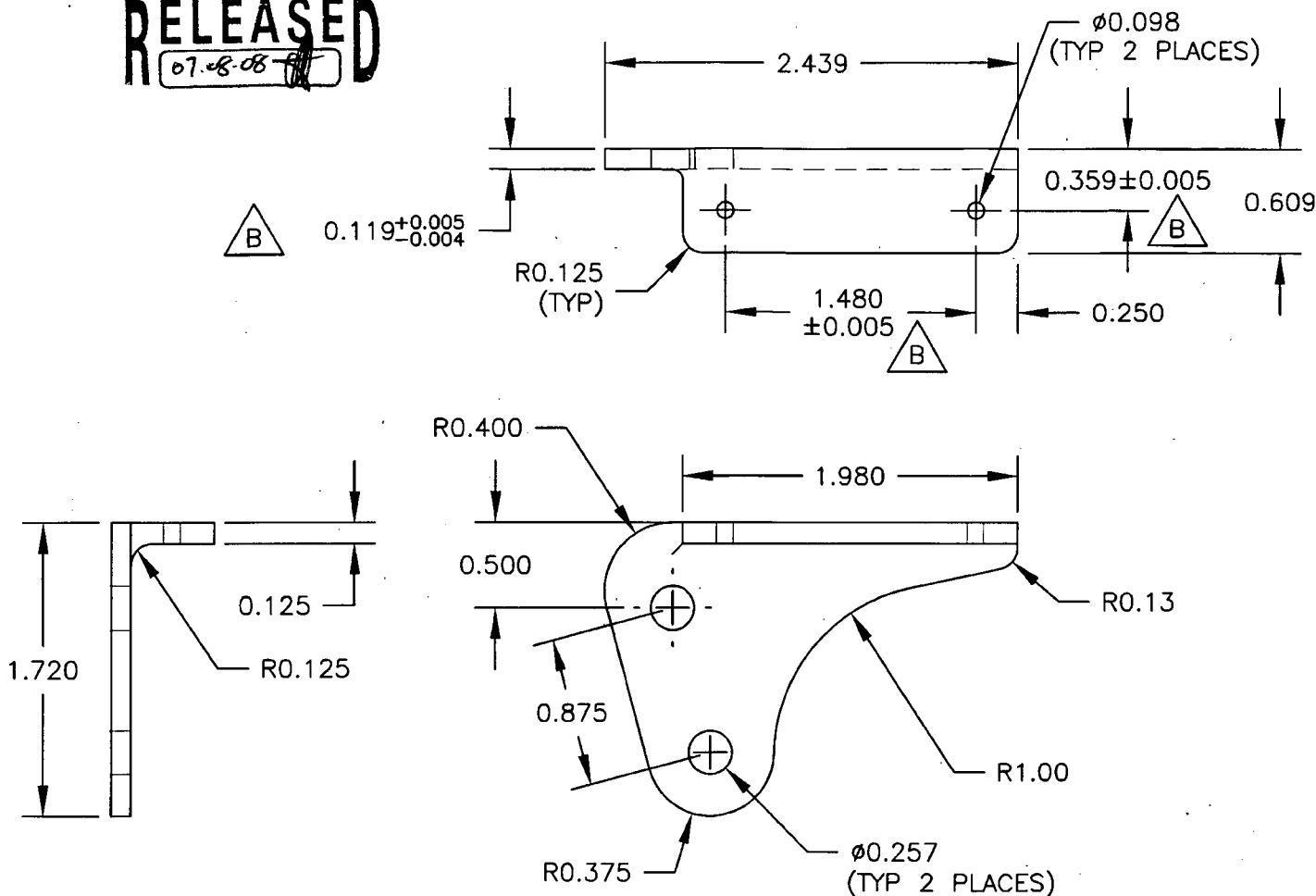
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DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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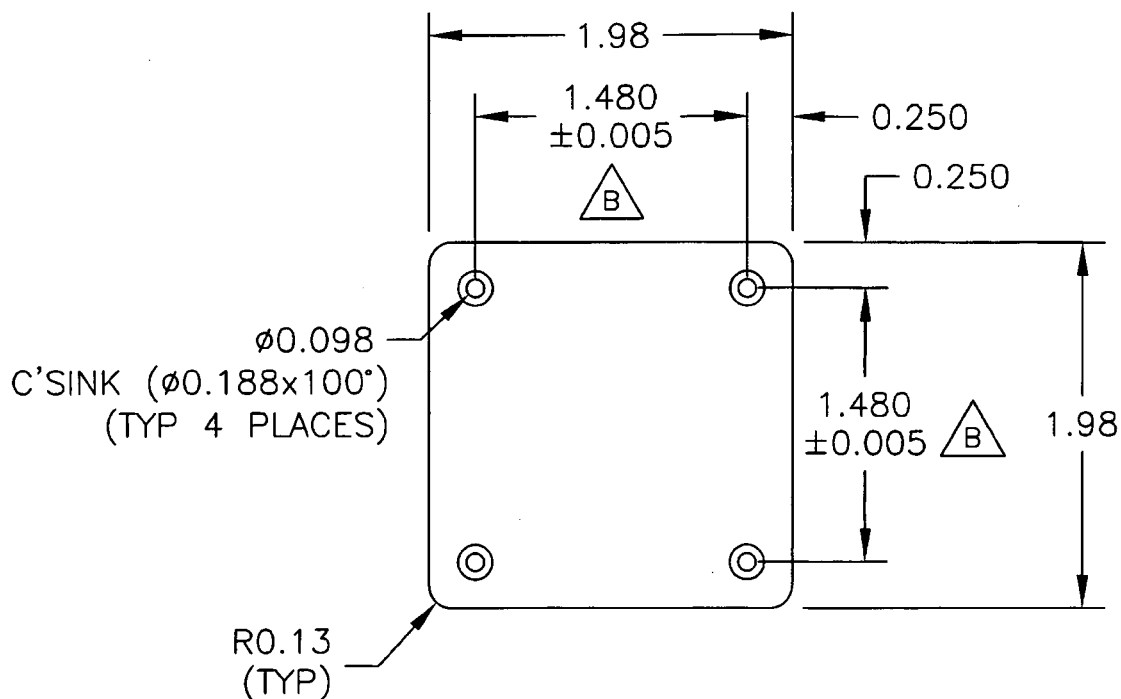
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DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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